



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-300
Job Sheet 170121



Part No: SWA10A-300

Job Qty: 6 ea

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA10A-300 Rev 5

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	6 pcs	1/18/18	1/18/18	0.00	0.60	Bandsaw1		
110	Mori Seiki	6 pcs	1/19/18	1/19/18	0.00	6.00	MORI NLX		
120	QC	6 pcs	1/19/18	1/19/18	0.00	0.00	QC2		
130	QC	6 pcs	1/19/18	1/19/18	0.00	0.00	QC8		
140	Packaging	6 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3 GA		
150	QC21-SA	6 Ea	1/19/18	1/19/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 3.560"

Descriptions: 110 - 1-Machine as per DWG. FB711 FOLIO REV: _____ DWG REV: _____ 2-Debur

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R4.000	2	5	0	0

Part Specifications

Specifications could not be found.

Plex 1/10/18 1:16 PM Dart.lajeunesse.marie

1.813
5030422

9.4 hrs

DART
AEROSPACE
S034293



Bearing Housing

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com
www.dartaerospace.com

PART NO: SWA10A-300
Original Serial #: S034293

Revision:

Operation:

Change No:

Start up Operation 01/22/18

Job No: 170121

DART AEROSPACE LTD		Work Order: 170121
Description: Bearing housing		Part Number: 100021
Inspection Dwg: SWA10A-360 Rev: 5		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.235	+0.003/-0.000	1.237	✓		Vern LPO8	
.125	+/- .005	.125				
1.020	+/- .005	1.017				
.245	+/- .005	.247				
1.017	+/- .005	1.018				
.095	+/- .005	.095				
.03x45°	+/- .01 x .5°	.03x45°				
.02x45°	+/- .01 x .5°	.02x45°				
Ø 2.165	+/- .001	2.164			Mic LPO8	
Ø 2.3521/2.3520		2.3524			NLX 2500	
R .015	+/- .005	.015			Rad gage	
Ø 3.071	+0.003/-0.000	3.073			Mic 104-137	
Ø 3.120	+/- .005	3.119			↓	
Ø 3.500	+/- .010	3.517			Mic 112-177	
.120	+0.005/-0.000	.122			Mic 005	
3/2 1605-113	G0 - NO G0	G0			Vern LPO8	
Ø 3.505	+0.000/-0.002	3.504			G0 gage	
Ø 3.710	+/- .006	3.7075			Mic 112-177	
Ø 3.950	+/- .005	3.951			Mic 104-137	
3.430	+/- .005	3.430			Height gage Height gage	
.680	+/- .005	.679			↓	
Ø 2.70	+/- .01	2.702			Vern LPO8	
R .25	+/- .01	.25			Rad gage	
.07x45°	+/- .01 x .5°	.075x45°			Vern LPO8	
.04x45°	+/- .01 x .5°	.04x45°			↓	

Measured by: <i>JP</i>	Checked by: <i>JP</i>	QC Inspector:
Date: 18-01-21	Date: 18/01/25	Date:

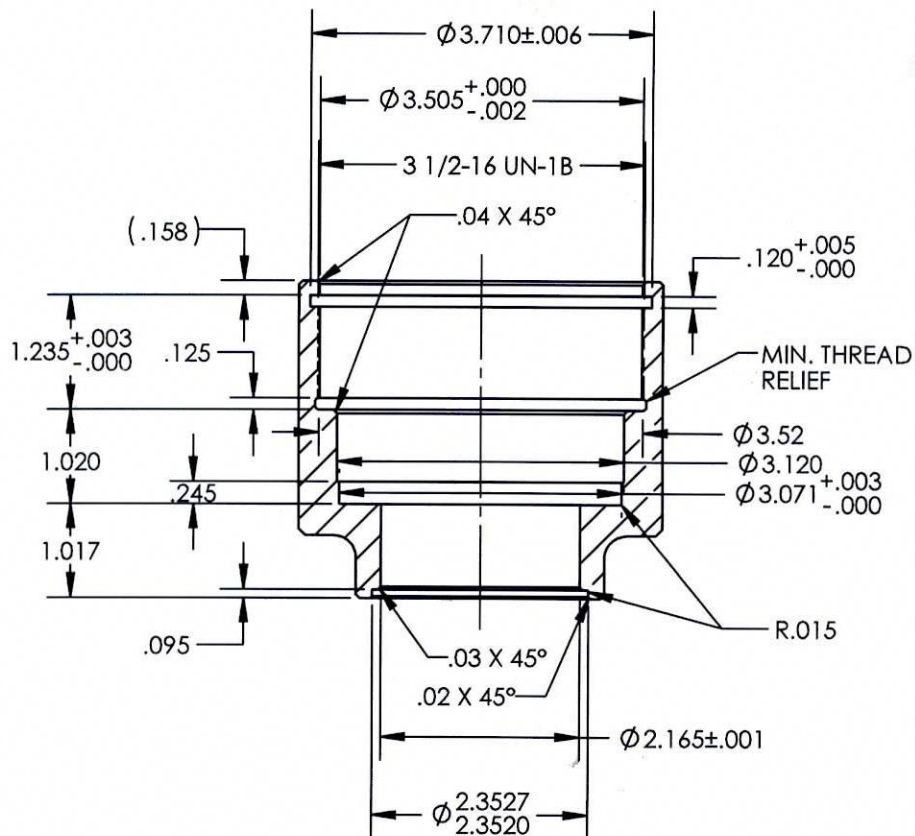
Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

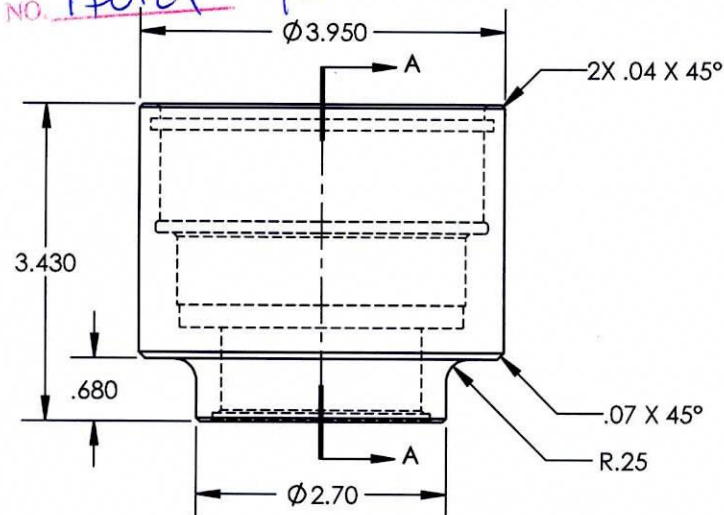
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	11/12/2012	JAG	
3		CH'D TOLERANCE OF Ø2.352+.003/-0.000 TO A LIMIT DIM.	11/16/2012	JAG	
4	15-0304	UPDATED TO NEW DRAFTING STANDARDS. ADDED MAT'L OPTION H1075.	10/16/2015	DPD	JAG
5	16-0252	CH'D THREAD DIM WAS 3-1/2-16 UN-2B IS 3-1/2-16 UN-1B, ADDED MIN. THREAD RELIEF NOTE.	12/5/2016	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170121



SECTION A-A



DART AEROSPACE	
TITLE BEARING HOUSING	
DWG NO. SWA10A-300	REV 5
MAT'L SS 17-4 H1150/H1075	
HEAT TREAT	UNLESS OTHERWISE SPECIFIED
FINISH	DIMENSIONS ARE IN INCHES
SPEC	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
	.XX $\pm .01$ ANGLES $\pm .5^\circ$
	.X $\pm .1$ SURFACES = 125/✓
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 X 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 2/21/2002	
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	